

86343

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 27/06/2012 **Start Qty:** 20.00

20

Cust Item ID:**Required Date:** 11/07/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals:

Process Plan: *Mr. J*

Date: 12/14/78

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86343

86.343

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June-27-12 3:19:54 PM

Item ID: D2432

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 206 (24") Bearpaw

Start Date: 27/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00

DA
14
2-8

12/07/16

20

10

150

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00

151

Packaging

Memo

PDP 86895 0.00 48
/M 87857 6.0

Packaging

12/17/17

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/17/20

12/07/17

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NOTE: Date & initial all entries

Picklist Print

June-27-12 3:19:58 PM

Page 1

Work Order ID: 86343

86343

Parent Item: D2432

D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	72.0100	3.7	74			

MUHMWB10

UHMW 1" Black

**

B12-7-5

Location

Loc Qty

Loc Code

MAT018

48.9

120972

1

121346

27.1

121954

20.8

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

122286

20

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86343
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060 ✓		VERN	PHD-01
B	5.500	+/-0.030	5.503 ✓		"	"
C	0.200	+/-0.030	0.195 ✓		Mic	PHD-09
D	0.25 x 45°	+/-0.030	0.250 ✓		M TAPE	PHD-11
E	R0.250	+/-0.030	0.250 ✓		R&C gauge	
F	0.250	+/-0.010	0.249 ✓		Mic	118-120
G	0.625	+/-0.030	0.628 ✓		VERN	PHD-01
H	0.375	+/-0.010	0.380 ✓		Mic	118-120
I	0.950	+0.030/0.010	0.958 ✓		VERN	PHD-01
J	19.000	+/-0.030	19.000 ✓		M TAPE	PHD-11
K	3.14	+/-0.030	3.152 ✓		VERN	PHD-01
L	3.28	+/-0.030	3.282 ✓		"	"
M	Ø0.260	+0.005/-0.000	0.260 ✓		"	"
N	Ø0.93	+/-0.030	0.931 ✓		"	"
O	0.30	+0.030/-0.000	0.308 ✓		Mic	PHD-09
P	23.750	+/-0.030	23.750 ✓		M TAPE	PHD-11
Q	7.375	+/-0.030	7.375 ✓		H gauge	
R	4.250	+/-0.010	4.250 ✓		VERN	PHD-01
S	2.000	+/-0.030	2.000 ✓		"	"
T	9.000	+/-0.010	9.000 ✓		H gauge	
U	9.000	+/-0.010	9.000 ✓		"	
V	0.375	+/-0.010	0.380 ✓		VERN	PHD-01

Measured by: PO/B.M.	Audited by: DAS 14	Prototype Approval:	N/A
Date: 12/07/10	Date: 12/07/16	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF

Dart Aerospace Ltd

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NOTE: Date & initial all entries

F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE P.M.S RF

RELEASED
98.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WORK ORDER
NO. 6343 KJ

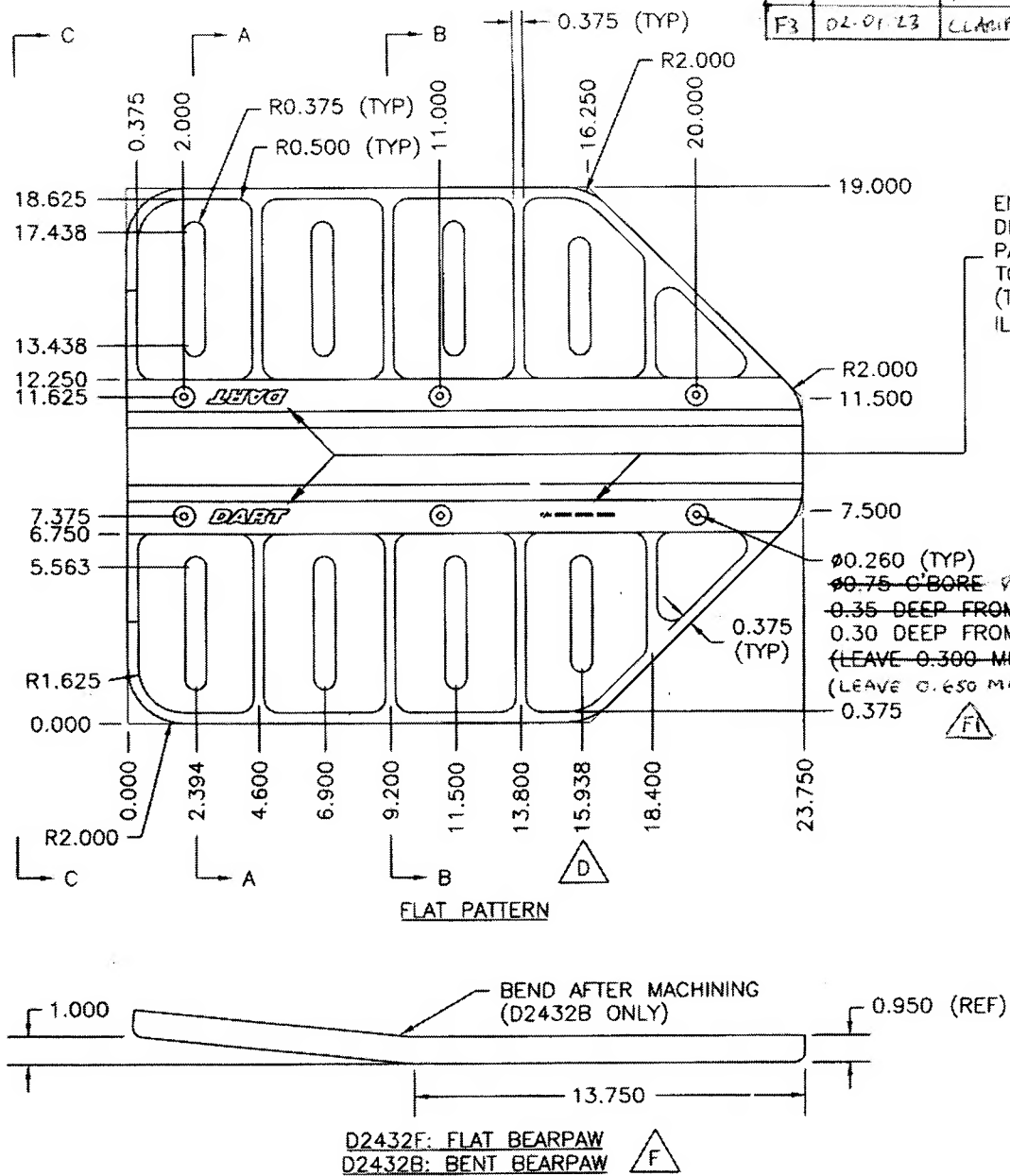
12/06/28



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM	AS	D2432
DATE	TITLE	SHEET 1 OF 2
98.05.12	BEARPAW	SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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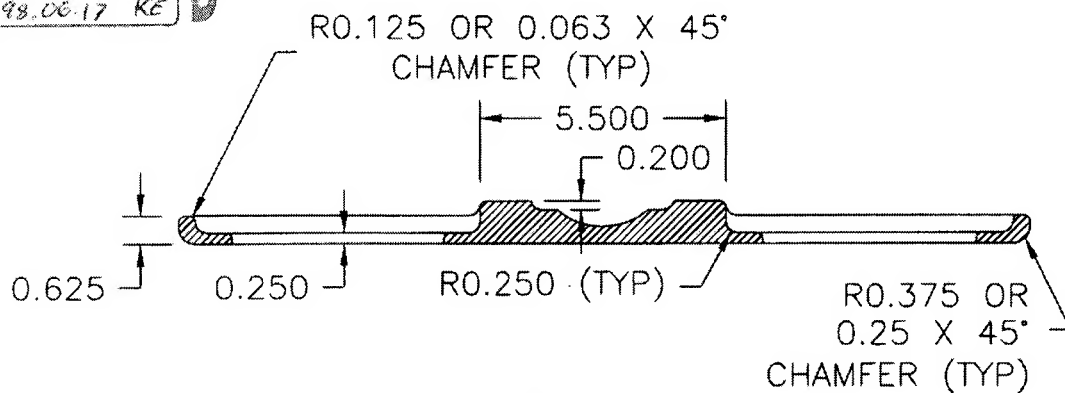
NOTE: Date & initial all entries

26343

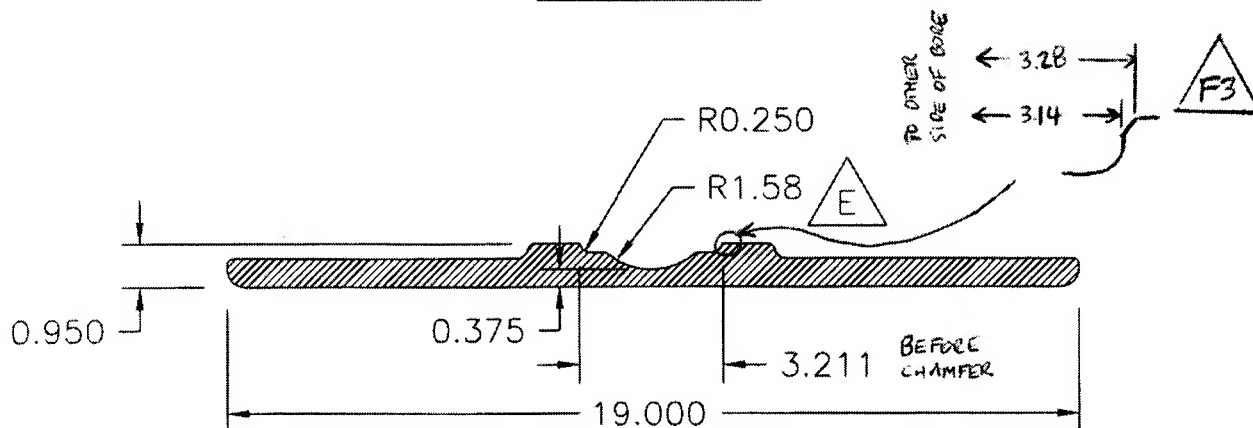


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

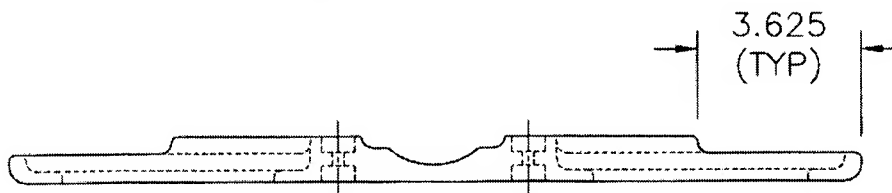
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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